

Work Order ID 118428

Thursday, July 10, 2014 8:35:39 AM

118428

Page 1

Item ID: D412-783-011 Repair

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop ***NS2***

Item Name: Gross Weight Towing Cable

Start Date: 7/9/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/10/2014 Req'd Qty: 1.00

1

Customer: CNATH16

Reference: RMA RA111826

Approvals: Process Plan: MF.Date: 14-7-10

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3943

E

IIN-D412-783

C

100

0.00

100

QC

Quality Control

Memo

INSPECT RA 111826

D412-783-011 REPAIR X 1 B98573

*CRANK NEEDS TO BE RECALIBRATED

*NEEDS TO BE DISSASSEMBLED, RESET AND CLEANED

Shp
14/7/10

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Quality Control

Memo

1-Calibrate and tag as per dwg and QSI 008 4.4

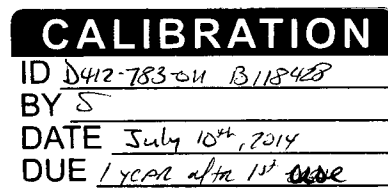
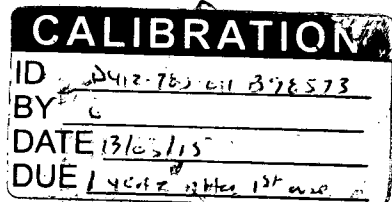
Calibration Cert. filled out

DAS

16

9-89

14/07/10



DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other _____ _____ _____
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Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 118428

Thursday, July 10, 2014 8:35:39 AM

118428

Page 2

Item ID: D412-783-011 Repair

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Gross Weight Towing Cable

Stop ***NS2***

Start Date: 7/9/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/10/2014 Req'd Qty: 1.00

1

Customer: CNATH16

Reference: RMA RA111826

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Identify as per dwg & Stock Location: <u>Ship</u>	0.00							
120									
Packaging	Memo	0.00							
Packaging									
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

MF 14-7-10

MW 14-7-16

MF 14-7-10

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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other		

Picklist Print

Thursday, July 10, 2014 8:35:29 AM

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Work Order ID: 118428

118428

Parent Item: D412-783-011 Repair

D412-783-011 Repair

Parent Item Name: Gross Weight Towing Cable

Start Date: 7/9/2014

Required Date: 7/10/2014

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D412-783-011 Repair

Manufactured

No

Each

0.0000

1

D412-783-011 Repair

1 x 98573

Gross Weight Towing Cable

MF 14-7-70

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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RA 111812 D412-783-011

B98573

Received @ Dart June 6th, 2014
Inspected@ Dart July 2nd, 2014

CUSTOMER: NATIONAL SECURITY
TECHNOLOGIES
CUSTOMER CONTACT: WADE FAHNESTOCK SR.
SHIPPED FROM: ANDREWS AFB MD, USA

Instructions for RA 111812 D412-783-011 B98573

- Crank assembly needs to be re calibrated
- Finish of part shows wear
 - Leave as is
- Needs to be disassembled and re set & cleaned
- Need work order to preform reworking
 - Will need new BATCH #
 - Must include new Calibration sheet

**CALIBRATION LABEL AND SHEET MUST BE
ATTACHED TO THE RA, THE WORK ORDER AND
ACCOMPANY THE PART TO THE CUSTOMER**

Time Estimate = 4 HOURS

Departments Required: large Fab

Pictures Attached = N/A

QTY INSPECTED = x1 D412-783-011 B98573

**THIS INSTRUCTION SHEET MUST
BE ATTACHED TO THE
RESTOCKING WORK ORDER AT
ALL TIMES!!!!**

DQA: _____ Date: _____



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INTERNAL CALIBRATION CERTIFICATE

Instrument #	Description	Serial #
D3943-041	Ground Handling Crank Assembly	B118428

Calibrated by	Date of calibration	Calibrated with	Due	Certificate #
ED	July 10th, 2014			

New tool	Disposed	In Repair	On Hold	Being Calibrated

Employee	Department	Comments:
N/A	N/A	MUST BE CALIBRATED WITH IN 1 YEAR OF PURCHASE OR FIRST OPERATION

Spec.	Tolerance is +/-	Result	Pass Fail
3500LBS	3500-3700LBS	3600LBS	PASS

Entered By:

Eric Downing

DAS
16
9-89

 2014/07/10